5/29

DART AEROSPACE LTD.	Work Order:	23783
Description: 206/OH-58 Saddle, inboard, Right Side	Part Number:	D2938-2
Drawing: D2938 Rev B	Qty:	6

Step	Location	Procedure	Ву	Date	qty
1	EXPEDITING	Issue Work Order	1	~ ~ ~	6
		Dug. not required RF 02/09/16	17	05.07.08	0
2	STORES	Issue material from stock: 7075-T7351 QQ-A-250/12			
		Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length	D. 1	11	1
		(D6101-003) Rf 3c/09/16 Batch No: 232241	M	0407/11	6
3	HAAS	Program batch number.	me	1.1	6
		*	12	05107/14	_
4	QC	Inspect part number and batch number are programmed			
		correctly.	0	05/07/14	0
5	HAAS	Machine Step No 1 of Folio and visually inspect as per dwg	· _ ' .		1
		D2938 & attached Dimension Sheet	13L	05.07.16	6
6	HAAS	Machine Step No 2 of Folio and visually inspect as per dwg	1.5		-
		D2938 & attached Dimension Sheet	ジイ	05.07.16	6
7	HAAS	Machine Step No 3 of Folio and visually inspect as per dwg			6
		D2938 & attached Dimension Sheet	J.L	65.07/6	ا جا
8	LAGUN	Machine Keyway and inspect per dwg D2938 & attached			1
		dimension sheet	スし	05.07.16	6
9.	METAL	Deburr	1		
•			J.L	05.67.16	(a
10	HAAS	Inspect Level 1	·		1
			15,2	05.07.16	6
11	QC	Inspect Level 8	-		
			13	05.07.14	6
12	METAL	Acid etch and Alodine as per QSI 005 4.1	N 0		
		The state of the s	PMC	05-7-21	6
13	FINISHING	Powder Coat Gloss White (4.3.5.1) per Dart QSI 005 4.3	1/2		
, 0	1 11110111110	Toward Gode Globb William (1.5.5.1) por Bare Qui God 1.5	H	050803	6
14	QC	Inspect Level 3	1		
,	4 0	I Hispool Level o	M	05 08 04	1
15	STORES	Pack in foam, identify and stock.	11/1	17 18 04	0
15	STORES	Fack in loans, lacinity and stock.	イナ	05/02/04	6
16	EXPEDITING	Close Work Order	Lax	C NO XICH	*
10	EVERNING	Job Cost / Part 105.88 542 08/08/05 (6)	-	0368K15	6
	L	97.5		147KB107	.

Rev	Date	Change	Revised By	Approved
Α	00.05.23	New Issue	EC	
В	00.06.26	New DWG rev (mpp 2069)	EC	

RELEASED

E2 00.06-25

Dart Aerospace Ltd	t
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W/O: WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE			Date	Qty -	Approval Mfg / Design Mgr	Approval QC Inspector
-				-				
						-		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B		Verification	A	A
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector
ı ·								
1								
	-							
1								
1								
1								*
1								
1								

Part No:	PAR #:	Fault Category: NO	CR:	Yes No DQA:	Date: <u>05/08/05</u>
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

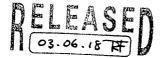
DART AEROSPACE LTD	Work Order:	23783
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

				Re	corded Actu	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	, 3	4	Ву	Date
Α	0.100	0.140		0.122	0.126	1.124	-123		
В	0.100	0.140		0 123	0.123	0.122	-120		
С	0.100	0.140		0.113	0.114	0.113	120	النخي	
D	0.210	0.230		0.218	0.218	0.219	- 219		
E	1.245	1.255		1.249	1.250	1.249	1.250		
F	1.245	1.255		1.2.44	1.249	1.249	1-249	,	
G	2.495	2.505		2.500	2,500	2,499	2.500		
Н	0.510	0.515		0.512	0.572	0.512	-5/2		
ı	1.572	1.582		1.377	1.577	1.576	1.576		
J	2.495	2.505		2 499	2,499	2-498	2497		
K	0.257،	0.262	DT8683				1		
L	0.312	0.317	DT8686						
М	0.235	0.240		0,238	0.238	0,238	.239		
N	0.100	0.140		0.118	0.118	0.118	118		
0	0.540	0.560		0.549	0.550	0.549	.548		
Р	0.490	0.510		0.500	0.504	0.502	##7.5d		
Q	3.715	3.725		3,718	3,717	3.718	3.7/8		
R	2.720	2.760		2.745	2,747	2.745	2.747		
S	0.240	0.270		0.246	0.246	0.246	-248		
T	0.100	0.180		k=300.150	0.142	0.145	.145		
U	1.625	1.635		1.628	1.629	1.1,28	1.628		
V	1.362	1.372		1.366	1.366	1.367	1367		
W	0.316	0.321	DT8690						
X	1.250	1.270		1.260	1.261	1.261	1.261		
Υ	1.565	1.585		1.578	1.572	1.572	1.572		
Z	·							. 1	
AA									
AB									
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AF			.*			, ,			
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	Acc	ept/Reje	et ·						

Measured by: M.L	ノブム	Audited by	Q	
Date:	05.07.16	Date:	05.07.17	
	/		· · · · · · · · · · · · · · · · · · ·	

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	N
В	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#



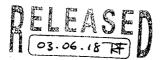
DART AEROSPACE LTD	Work Order:	23783
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

				, Re	corded Actu	ıal Dimensio	ns		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		-126	-127				
В	0.100	0.140		-125	124				
С	0.100	0.140		.126	-127				
D	0.210	0.230		୍ଥର୍	-219				
Е	1.245	1.255		1.249	1250				
F	1.245	1.255		1-250	1-249				
G	2.495	2.505		2-500	2-417				
Н	0.510	0.515		-512	.5/2				
J	1.572	1.582		1.576					
J	2.495	2.505		2.497	2.496				
K	0.257	0.262	DT8683				1		
L	0.312	0.317	DT8686						
M	0.235	0.240		-239	-237				
Ν	0.100	0.140		-118	-118				
0	0.540	0.560		-548	.547				
Р	0.490	0.510		- 500	-501				
Q	3.715	3.725		3.719	37/8				
R	2.720	2.760		2.747	2,748				
S	0.240	0.270		-248	-247				
Т	0.100	0.180		.145	- 145				
U	1.625	1.635		1.629	1-628				
V	1.362	1.372		1.367	1-366				
W	0.316	0.321	DT8690		1		 		
X	1.250	1.270		1.263	1.262				
Y	1.565	1.585		1.572	1.572				
Z									
AA									***************************************
AB									
AC							·· ·· · · · · · · · · · · · · · · · ·		
AD									
ΑE					.,				
AF									
AG									
AH							*****		
	Acc	ept/Rejec	ct						

Measured by: 7_L	Audited by	R	
Date: 05.07./6	Date:	05-07.1	7

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	N
В	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	4



	Job Costing Re	eport	
Dart Aerospace Ltd Hawkesbury	_	Jul 08, 2005 01:32 pm	
Project For ' Work Order Type Main WO Number House *Part Number	: : D2938-2)6 Saddle Right side	Department Code: Burden Flags : NNNNNNN WO Status : Open Invoice State : Not Invoiced Invoice Date : Invoice Number : Invoice Amount : 0.00 Order Entry No :	
Start Date Est Finish Date	: 07-08-05 : 07-23-05	OE Value : 0.00	
Act Finish Date Drawings Reqd	: : No	Est Mark Up : 0.000% Actual Mark Up : 0.000%	
Ok for Approval Approval Rec'd		\$0 Posted to Finished Goods	
	Estimated Actual	Var. % Posted To Post	:
Material Cost Engineering Hours	: 0.00 0.00 : 0.00 0.00	0.00 0.00 0.00 0.00)
Engineering Hours Engineering Cost Production Hours	0.00 0.00	0.00 0.00 0.00 0.00	1
Production Cost Packaging Hours	0.00 0.00	0.00 0.00 0.00 0.00)
Packaging Cost OverHead Hours	: 0.00 0.00	0.00 0.00 0.00	l

Material Cost	:	0.00	0.00	0.00	0.00	0.00	
Engineering Hours	:	*0.00	0.00	0.00			
Engineering Hours Cost	: •	0.00	0.00	0.00	0.00	0.00	
Production Hours	:	0.00	0.00	0.00			
Production Cost	:	0.00	0.00	0.00	0.00	0.00	
Packaging Hours	:	0.00	0.00	0.00			
Packaging Cost	:	0.00	0.00	0.00	0.00.	0.00	
OverHead Hours	:	0.00	0.00	0.00			
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00	
CNC Hours	:	0.00	0.00	0.00			
CNC	:	0.00	0.00	0.00	0.00	0.00	
Misc. Hours	:	0.00	0.00	0.00			
Misc.	:	0.00	0.00	0.00	0.00	0.00	
		=======================================	======	=======			
Burden	.:	0.00	0.00	0.00		4	
		=======================================	======	=======			
Total Cost	:	0.00	0.00	0.00			
Mark up	:	0.000	0.000			•	
Selling Cost	:	0.00	0.00		en e	į	
•							

		Estimated	Actual:
Labour Hrs/Amount Done	:	0.00	0.00 /
Profits/(Loss)	:	0.00	0.00